

Work Order ID 58315

May 3, 2010 11:42:35 AM



Page 1

Item ID: D4030-043

Accept



Setup Start



Revision ID:

Item Name: Long Basket Assembly, Light Lid (350)

Stop



Start Date: 03/05/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: mfDate: 10-5-3

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4030

B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

P14/6/2 ①

110

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

E/S 10/06/03 ②

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sidoblos40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

May 3, 2010 11:42:35 AM



Accept



Setup Start



Stop



Start Date: 03/05/2010 **Start Qty:** 1.00

**Cust Item ID:**

Required Date: 13/05/2010 **Req'd Qty:** 1.00



Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start



Stop



Operation Description

Set Up/ Run Hours

Draw Number

Draw
Rev.

Plan
Code

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

130

Identify as per dwg & Stock Location:_____

0.00



Packaging

Memo

PSP
58321

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10660479

mf
10-6-4

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Picklist Print

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Page 1

Work Order ID: 58315

Parent Item: D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 03/05/2010

Required Date: 13/05/2010

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC
per dwg revB DD 10.04.20 verified by:EC

IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D2530 Handle Weldment		Manufactured	No			100	Each	3.0000	1			

Location Loc Qty Loc Code

ST506 3
57736 3

D2535 Spring		Manufactured	No			100	Each	11.0000	2			
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Location Loc Qty Loc Code

ST504 11
56355 11

D2537 Bushing		Manufactured	No			100	Each	23.0000	4			
------------------	--	--------------	----	--	--	-----	------	---------	---	--	--	--

Location Loc Qty Loc Code

ST504 23
53181 3
57722 20

D3913-041 Long Basket Base Assembly, 350		Manufactured	No			100	Each	0.0000	1			
---	--	--------------	----	--	--	-----	------	--------	---	--	--	--

D3915-041 Light Lid Assembly, Long Basket		Manufactured	No			100	Each	0.0000	1			
--	--	--------------	----	--	--	-----	------	--------	---	--	--	--

B59082 (K)

B58324 (K)

E/S 10/06/03

E/S 10/06/03

14/6/2 ①

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IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3917-3 Washer		Manufactured	No			100	Each	1.0000	6	58892		

Location Loc Qty Loc Code

ST096 1
57144 1

D3953-3 Gas Spring Stud, Lid		Manufactured	No			100	Each	7.0000	2	58894		
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Location Loc Qty Loc Code

ST101 7
53757 1
57978 6

D3953-7 Spring Spacer		Manufactured	No			100	Each	15.0000	2	58893		
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Location Loc Qty Loc Code

ST101 15
53970 15

D3953-9 Gas Spring Washer		Manufactured	No			100	Each	30.0000	2			
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Location Loc Qty Loc Code

ST101 30
53642 30

53642

10/10/2 ①

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Shop Packet Print

Page 2

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IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3953-17 Gas Spring Spacer		Manufactured	No			100	Each	8.0000	2	58857		

Location Loc Qty Loc Code

ST101

8

57143

8

D3953-19

Manufactured No

100

Each

14.0000

1

Gas Spring Bracket

Location Loc Qty Loc Code

ST101

14

57607

14

D3953-21

Manufactured No

100

Each

22.0000

1

Gas Spring Bracket

Location Loc Qty Loc Code

ENG

6

56407

6

ST102

16

57145

16

D3969-3

Manufactured No

100

Each

3.0000

1

Spring (Basket Lid)

Location Loc Qty Loc Code

ENG

3

55716

3

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Page 3

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Page 4

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Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 03/05/2010


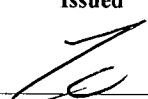
Required Date: 13/05/2010

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC
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IPP Rev:B as



Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
AN3-14A  Bolt		Purchased	No			100	Each	98.0000	4	-		



Location Loc Qty Loc Code

ST351 98
114330 98

AN3-20A  Bolt		Purchased	No			100	Each	45.0000	2	114330		
--	--	-----------	----	--	--	-----	------	---------	---	--------	---	--


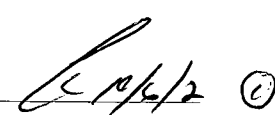
Location Loc Qty Loc Code

ST352 45
105125 45

AN4-12  Bolt		Purchased	No			100	Each	53.0000	3	105125		
---	--	-----------	----	--	--	-----	------	---------	---	--------	---	--

Location Loc Qty Loc Code

ST357 53
104016 3
114292 50

AN5-17A  Bolt		Purchased	No			100	Each	169.0000	2	OK M114292		
--	--	-----------	----	--	--	-----	------	----------	---	------------	---	--

Location Loc Qty Loc Code

ST323 64
114324 64
ST339 105
113538 5
114330 100

M114324

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

AN5-21A

Purchased

No

100

Each

16.0000

2

Bolt

Location

Loc Qty

Loc Code

ST339

16

16463

16

AN310-4

Purchased

No

100

Each

64.0000

3

NUT

Location

Loc Qty

Loc Code

ST139

30

114341

30

ST314

14

113845

14

ST349

20

114341

20

AN310C4

Purchased

No

100

Each

82.0000

2

Nut

Location

Loc Qty

Loc Code

ST349

82

114306

82

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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IPP Rev:B as

Start Date: 03/05/2010


Required Date: 13/05/2010

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MS21042L3		Purchased	No			100	Each	1,762.000	- 6			
												
Nut												

Location	Loc Qty	Loc Code
ST300	1762	
113537	20	
113644	742	
114523	1000	

MS21042L5		Purchased	No			100	Each	697.0000	- 4			
												
Nut												

Location	Loc Qty	Loc Code
ST300	697	
113523	26	
113537	3	
114108	168	
114437	100	
114449	400	

MS24665-151		Purchased	No			100	Each	701.0000	3			
												
Cotter Pin												

Location	Loc Qty	Loc Code
ST309	701	
17566	701	

May 3, 2010 11:42:41 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 7

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Start Date: 03/05/2010




Required Date: 13/05/2010

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC
per dwg revB DD 10.04.20 verified by:EC

IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MS24665-300		Purchased	No			100	Each	92.0000	2			
												
Cotter Pin												

Location Loc Qty Loc Code

ST309 92
105279 2
110123 90

NAS1149F0432P Purchased No

100 Each 93.0000

6



Washer



M11423

M114576

Location Loc Qty Loc Code

ST275 93
112940 92
114405 1

NAS1149F0563P Purchased No

100 Each 72.0000

4



Washer



Location Loc Qty Loc Code

ST275 72
108471 72

108471

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

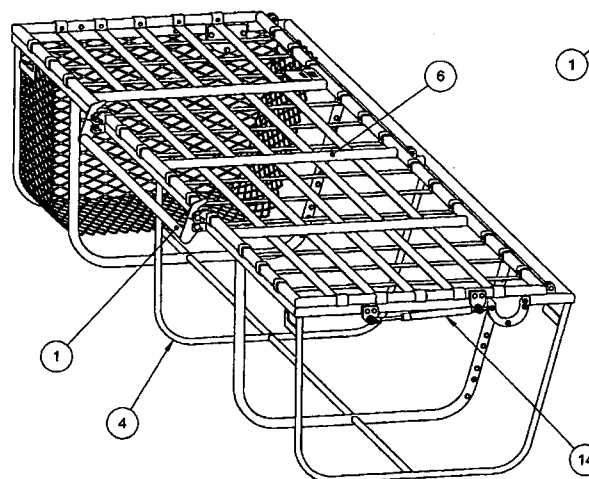
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

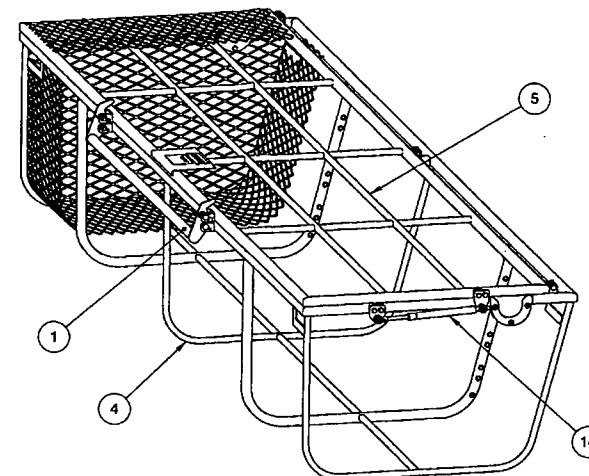
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ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	4	4	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1		D3914-041	LONG BASKET LID ASSY (350)
6		1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8		NAS1149F0332P	WASHER
31	2		NAS1149C0432R	WASHER



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.04.06		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4030	REV. B SHEET 1 OF 3
TITLE LONG BASKET ASSY (350)	SCALE NTS
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RELEASED
2010-04-14
AMP

58315

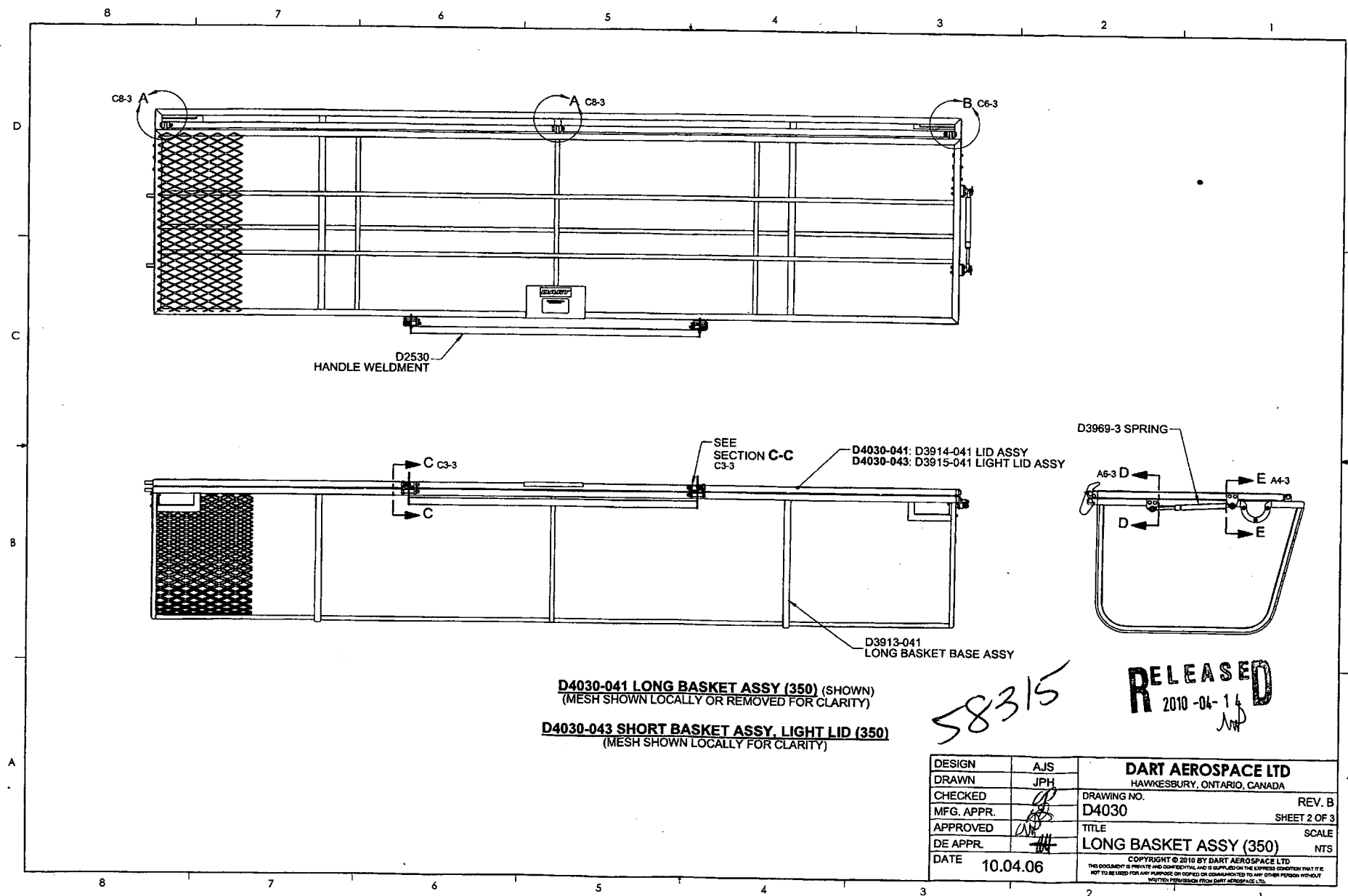
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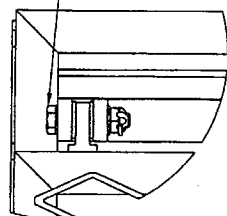
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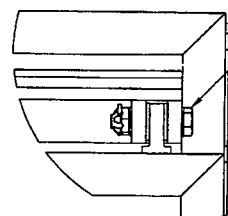
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AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



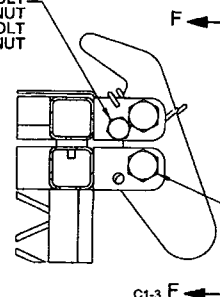
DETAIL A D8-2
D5-2



DETAIL B D3-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN

D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT



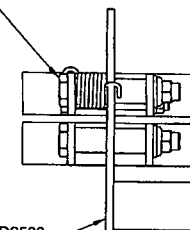
SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

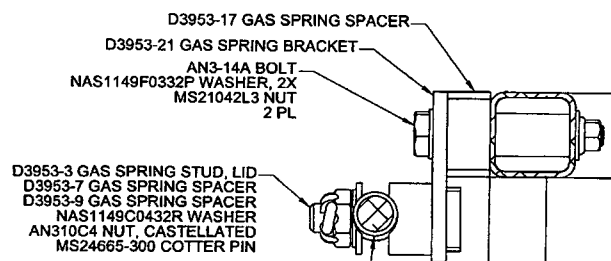
D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

AN5-17A BOLT
D2537 BUSHING
NAS1149F0563P WASHER
MS21042L5 NUT

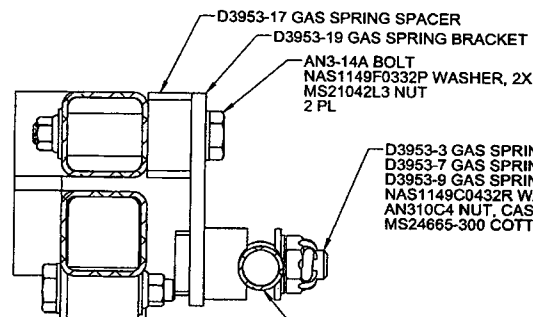
D2530
HANDLE WELDMENT
REF



VIEW F-F C3-3



SECTION D-D B2-2



SECTION E-E B1-2

58315

RELEASED
2010-04-14
MP

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	GP	DRAWING NO.	REV. B
MFG. APPR.	GP	D4030	SHEET 3 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	LONG BASKET ASSY (350)	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries